

Date Wednesday, 15/08/2007 4:00:38 PM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW		
Job Number	: 33944		Part Number	: D29381UP		
Estimate Number	: 12926		Drawing Number	: D2938 REV C		
P.C. Number	: N/A		Project Number	: N/A		
This Issue	: 15/08/2007	S.O. No. : N/A	Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/09/2007		
Previous Run	: N/A		Qty:	10	Um:	Each
Written By:	<u>JL/07-08-16</u>					
Checked & Approved By						
Comment	: Est Rev.A New Issue 07-07-04 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101003	<p>7075-T7351 2X6.25X7.875</p> <p>Comment: Qty : 1.0000 Each(s)/Unit Total : 10.0000 Each(s)</p> <p>Issue material from stock: 7075-T7351 (QQ-A-250/12)</p> <p>Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length</p> <p>(D6101-003) Batch No: <u>B31387</u></p> <p>JL 07/08/20</p>
2.0	HAAS1	<p>HAAS CNC VERTICAL MACHINING #1</p> <p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>Program part number and batch number.</p> <p>1-Inspect part number and batch number are programmed correctly.</p> <p>2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 &amp; attached Dimension Sheet</p> <p>3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 &amp; attached Dimension Sheet</p> <p>4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 &amp; attached Dimension Sheet</p> <p>5-Deburr</p> <p>SD/JL 07/08/23</p>
3.0	MILLING CONV.	<p>CONVENTIONAL MILLING MACHINE</p> <p>Comment: CONVENTIONAL MILLING MACHINE</p> <p>Machine Keyway and inspect per attached dimension sheet</p> <p>SD/JL 07/08/23</p>
4.0	QC1	<p>INSPECT ALL DIM TO DIM SHEET</p> <p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p>SD/JL 07/08/23</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/08/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:38 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 33944

Part Number: D29381UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/08/23 10

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ 07-08-24

10

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

h 07-08-24

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 495

h 07-08-24

10

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/07

Job Completion



h 07-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

Description: 206 Saddle, Outboard, Left side

Part Number: D2938-1

Inspection Dwg: D2938 Rev. C

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.126	.125	.125	.127		
B	0.100	0.140		.128	.126	.125	.126		
C	0.100	0.140		.126	.120	.119	.124		
D	0.210	0.230		.221	.223	.225	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.121	.125	.127	.127		
O	0.540	0.560		.550	.550	.558	.550		
P	0.490	0.510		.501	.498	.491	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.249	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.254	1.264	1.267	1.265		
Y	1.565	1.585		1.567	1.576	1.582	1.579		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L / SA  
 Date: 07.08.21

Audited by: *SM*  
 Date: 07/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JLM</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:		
Description: 206 Saddle, Outboard, Left side				Part Number:		D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.125	.123	.126		
B	0.100	0.140		.127	.126	.124	.124		
C	0.100	0.140		.122	.121	.120	.122		
D	0.210	0.230		.223	.225	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.520	.570	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262		.259	.257	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.239	.239	.239		
N	0.100	0.140		.120	.120	.123	.123		
O	0.540	0.560		.548	.545	.550	.550		
P	0.490	0.510		.497	.498	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.180	.140	.135	.135		
U	1.625	1.635		1.630	1.630	1.620	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.265	1.265	1.262	1.263		
Y	1.565	1.585		1.579	1.577	1.576	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: SD / J.L  
Date: 07/08/23

Audited by: *ml*  
Date: 07/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>ml</i>	<i>ml</i>

DART AEROSPACE LTD			Work Order:	
Description: 206 Saddle, Outboard, Left side			Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.122				
B	0.100	0.140		.123	.120				
C	0.100	0.140		.121	.120				
D	0.210	0.230		.220	.222				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.316	.316				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.123	.124				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.719	3.700				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.251	.252				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.321	.321				
X	1.250	1.270		1.262	1.262				
Y	1.565	1.585		1.575	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	<i>2nd</i>
Date:	07/08/23	Date:	07/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>